

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014312**Date Inspected:** 21-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Bernard Docena, Bnifacio Daquing			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	SAS OBG		

Summary of Items Observed:

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as 2W/3W-C, 1W/2W-C/D and the following observations were made:

5E/6E-A

Upon the arrival of the QA Inspector it was randomly observed the ABF welding Superintendent Dan Ieraci was setting up the submerged arc welding (SAW) machines in preparation of performing the SAW root pass. The QA Inspector noted the shielded metal arc welding (SMAW) full length tack weld was previously deposited on both sides of the weld joint against the bevel and the steel backing bar. The QA Inspector randomly observed the ABF welding personnel had pre determined and indicated with a distinguishing marking on base material the sequencing in which the joint would be welded. The QA Inspector observed the weld was broken into 5 sections beginning in the center and moving outward toward the edges of deck plate.

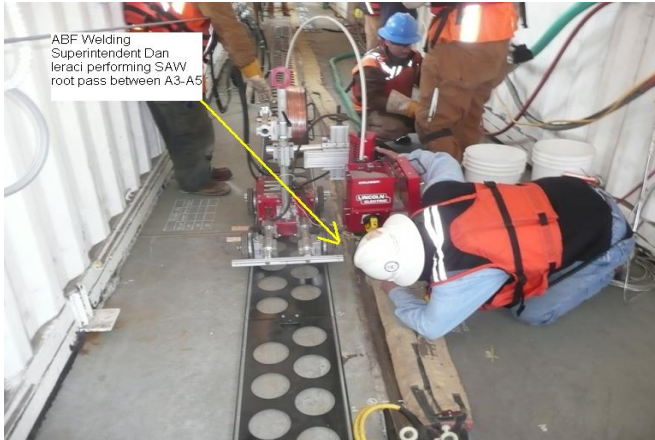
A3-A5

The QA Inspector randomly observed the ABF welding operator/Superintendent Dan Ieraci began welding the SAW root pass in the center of A3 and weld to the end of section A5. The QA Inspector randomly observed the SAW parameters and they were 555 Amps, 32.3 Volts and a travel speed of 368mm/min. The QA Inspector noted the SAW parameters appeared to be in general compliance with ABF-WPS-D1.5-4042B-1. After the root pass was completed between the center of A3-A5, the SE QC Inspectors were setting up to perform the magnetic particle testing (MT) prior to the 1200 lunch break. The QA Inspector noted no additional ABF welding operator began performing the SAW root pass between A3-A1. The QA Inspector randomly observed the ABF welding operator

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Jordan Hazelaar attempt to begin the SAW root pass before he was stopped by Dan Ieraci. Mr. Ieraci informed the ABF welder he would perform the root pass him self. The QA Inspector noted the SAW root pass between A1-A3 was not completed on the QA Inspectors shift.



Summary of Conversations:

At 0745 the QA Task Lead Inspector Bill Levell verbally informed the QA Inspector ABF has approval to begin welding at the above identified location. Later in the QA Inspectors shift the Caltrans Structures Representative Paul Jefferson informed the QA Inspector of the approval to weld the above identified weld joint. Mr. Jefferson went on to inform the QA Inspector it was determined in a meeting yesterday by Caltrans engineers the planar misalignment previously discovered and recorded could be corrected by welding and by transitioning with a 2.5:1 slope by grinding.

The Caltrans Structures Representative Sami Dauk informed the QA Inspector approximately 450 bolts were loosened or removed. Mr. Dauk informed the QA Inspector he has already informed the ABF Erection Foreman Darrel Webb the bolts which have been loosened are no longer acceptable fasteners for the project and they must be discarded. Mr. Webb informed Mr. Dauk additional bolts will be ordered to take the place of the bolts which were loosened after they had been tensioned.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
